

Thursday, 11/29/2007 11:01:05 AM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SADDLE
Job Number	: 36016		
Estimate Number	: 12451		
P.O. Number	:	Part Number	: D35001
This Issue	: 11/29/2007 S.O. No. :	Drawing Number	: D3500 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 /	Drawing Revision	: C
Previous Run	: 35781	Material	:
		Due Date	: 1/5/2008
Written By	:	Qty:	20 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: A New Issue 06-06-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102013	6061-T6 7.0x6.5x2.0
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

6061-T6 7.0x6.5x2.0

350 Saddle Billet

Batch: B-356005 DJP 08/03/20

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 36016 Double check by: MA

1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets

4-Deburr

5-Tumble to remove sharp edges.

DJP 08/03/20

SA 08/03/20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/03/22

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 08/03/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:01:06 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 36016

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(20)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR

08-03-25

6.0

POWDER COATING

POWDER COATING



M 10700 S



(20X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h

08/03/25

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



43



Comment: INSPECT POWDER COAT

08-03-25

(20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST440

PC 8/3/26

(20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

Job Completion



mf

08-03-27

(20)

W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 36016
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500		Rev: C
		Page 1 of 1

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.483	0.490		0.487	.484	.484	.484		
B	1.175	1.185		1.178	1.179	1.179	1.179		
C	3.145	3.155		3.149	3.149	3.149	3.149		
D	1.175	1.185		1.177	1.179	1.179	1.179		
E	0.365	0.385		0.380	.382	.382	.382		
F	0.490	0.510		0.498	.501	.501	.501		
H	R.470	R.530		0.525	.525	.525	.525		
I	R1.575	R1.595		1.580	1.587	1.585	1.580		
J	0.240	0.260		0.251	.247	.247	.249		
K	0.490	0.510		0.500	.499	.499	.499		
L	3.590	3.650		3.620	3.615	3.615	3.615		
M	0.315	0.320		0.320	.320	.320	.320		
N	0.256	0.262		0.259	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		5.999	5.999	6.000	5.999		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.4985	2.500	2.500	2.500		
S	2.245	2.255		2.252	2.251	2.251	2.250		
T	1.120	1.130		1.123	1.123	1.125	1.125		
U	0.540	0.560		0.552	.545	.549	.552		
V	0.793	0.803		0.798	.798	.798	.798		
W	R.240	R.260		0.250	.250	.250	.250		
X	0.040	0.060		0.045	.052	.052	.050		
Y	0.100	0.120		0.115	.112	.110	.112		
AA	R1.125	R1.145		1.130	1.133	1.135	1.130		
AB	R.490	R.510		0.500	.500	.500	.500		
AC	0.615	0.635		0.625	.635	.635	.635		
AD	0.240	0.260		0.255	.250	.250	.250		
AE	1.810	1.830		1.8125	1.825	1.825	1.819		
AF	0.240	0.260		0.2485	.250	.250	.246		
AG	0.140	0.160		0.148	.148	.148	.145		
AH	0.140	0.160		0.149	.146	.147	.143		
AI	0.140	0.160		0.149	.147	.147	.145		
Accept/Reject									

Measured by:	DJP / JF
Date:	08/03/20 / 08/23/22

Audited by:	SA
Date:	08/03/24

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	JF

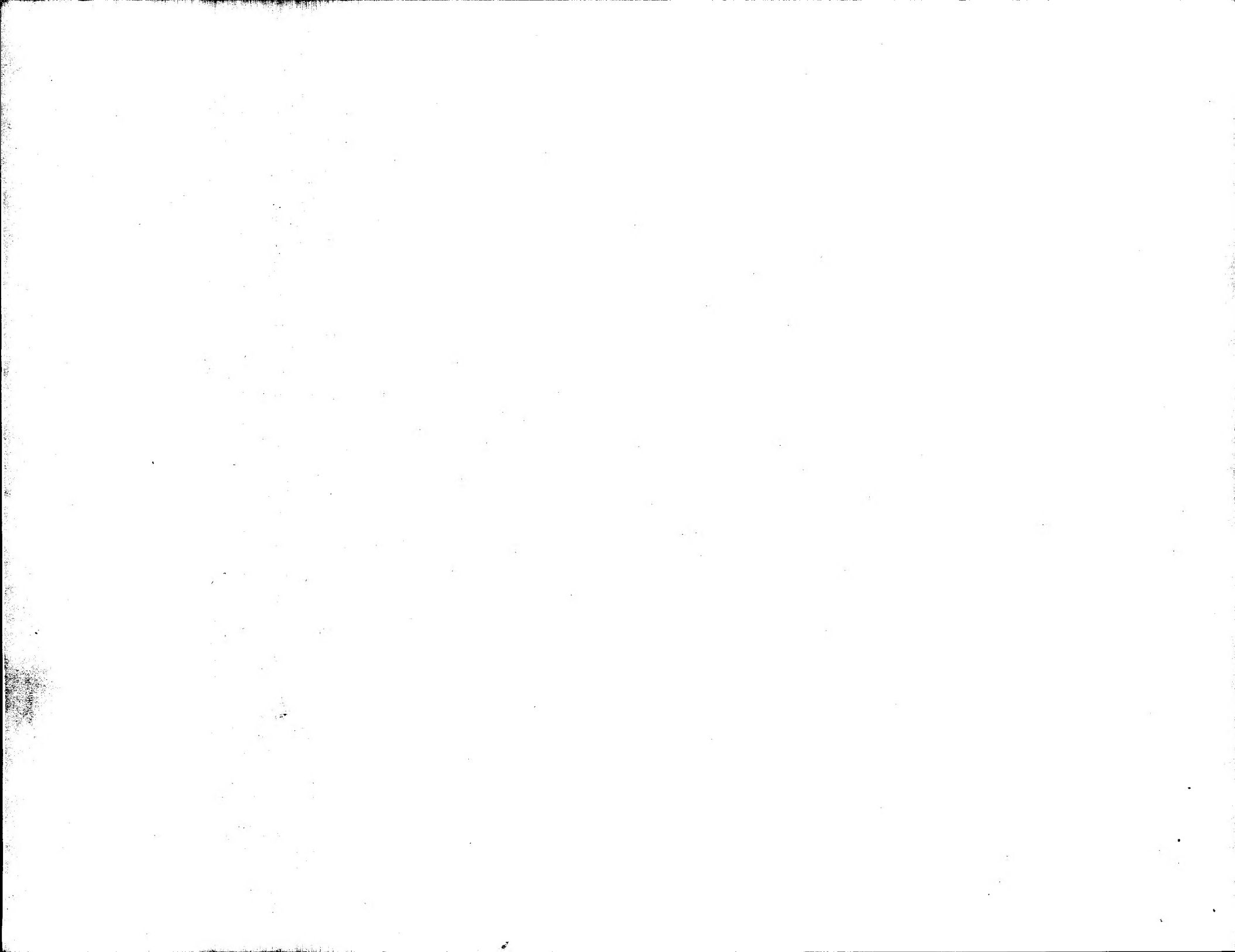
DART AEROSPACE LTD		Work Order:	36016
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5x	6x	7x	4x	By	Date
A	0.483	0.490		.486	.485	.485	.486		
B	1.175	1.185		1.180	1.180	1.180	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.180	1.180	1.179		
E	0.365	0.385		.384	.380	.385	.377		
F	0.490	0.510		.500	.501	.500	.500		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.249	.247	.247	.247		
K	0.490	0.510		.501	.500	.501	.500		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.500	6.513	6.511	6.501		
P	5.990	6.010		6.000	6.005	6.005	6.000		
Q	2.820	2.830		2.825	2.825	2.824	2.824		
R	2.495	2.505		2.501	2.501	2.501	2.501		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.552	.551	.551		
V	0.793	0.803		.799	.799	.799	.799		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.108	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.630		
AD	0.240	0.260		.250	.251	.251	.251		
AE	1.810	1.830		1.825	1.825	1.825	1.825		
AF	0.240	0.260		.247	.253	.250	.250		
AG	0.140	0.160		.146	.149	.149	.149		
AH	0.140	0.160		.151	.150	.150	.150		
AI	0.140	0.160		.147	.147	.147	.146		
Accept/Reject									

Measured by:	LF
Date:	08/03/22

Audited by:	SA
Date:	08/03/22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	



DART AEROSPACE LTD				Work Order:	36016
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	91	102	198	124	By	Date
A	0.483	0.490		.484	.485	.485	.485		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.251	.252	.247	.247		
K	0.490	0.510		.500	.501	.501	.501		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.500	6.510	6.570	6.570		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.820	2.820	2.820	2.820		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.551	.551	.551		
V	0.793	0.803		.799	.799	.799	.799		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.051	.051	.051		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.250	.257	.257	.257		
AE	1.810	1.830		1.825	1.823	1.823	1.825		
AF	0.240	0.260		.250	.250	.257	.257		
AG	0.140	0.160		.149	.148	.149	.149		
AH	0.140	0.160		.150	.150	.149	.149		
AI	0.140	0.160		.148	.148	.147	.147		
Accept/Reject									

Measured by:	RF
Date:	08/03/22

Audited by:	SA
Date:	08/03/24

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	36016
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
A	0.483	0.490		.484	.484	.485	.485		
B	1.175	1.185		1.179	1.179	1.179	1.178		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.178		
E	0.365	0.385		.375	.375	.378	.375		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.585	1.582	1.587	1.587		
J	0.240	0.260		.247	.247	.247	.247		
K	0.490	0.510		.500	.500	.498	.500		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.500	6.510		
P	5.990	6.010		6.001	6.001	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.554	.550		
V	0.793	0.803		.799	.799	.799	.799		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.060	.060	.060	.060		
Y	0.100	0.120		.115	.115	.115	.115		
AA	R1.125	R1.145		1.135	1.132	1.137	1.137		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.631	.635	.635		
AD	0.240	0.260		.256	.257	.256	.257		
AE	1.810	1.830		1.825	1.825	1.826	1.826		
AF	0.240	0.260		.251	.250	.248	.248		
AG	0.140	0.160		.149	.148	.150	.150		
AH	0.140	0.160		.150	.150	.150	.150		
AI	0.140	0.160		.148	.148	.147	.145		
Accept/Reject									

Measured by:	JS
Date:	08/03/23

Audited by:	SN
Date:	08/03/24

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	JS

DART AEROSPACE LTD		Work Order:	36016
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	18	19	20	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		.378	.378	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.585	1.584	1.585	1.589		
J	0.240	0.260		.248	.245	.245	.245		
K	0.490	0.510		.501	.500	.500	.500		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.001	6.001	6.001	6.001		
Q	2.820	2.830		2.825	2.825	2.828	2.828		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	2.125	2.125		
U	0.540	0.560		.551	.550	.550	.550		
V	0.793	0.803		.799	.799	.799	.799		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.115	.115	.115	.115		
AA	R1.125	R1.145		1.138	1.135	1.131	1.138		
AB	R.490	R.510		.510	.510	.510	.510		
AC	0.615	0.635		.635	.635	.631	.635		
AD	0.240	0.260		.252	.252	.252	.252		
AE	1.810	1.830		1.825	1.820	1.825	1.820		
AF	0.240	0.260		.251	.251	.251	.255		
AG	0.140	0.160		.145	.149	.149	.150		
AH	0.140	0.160		.150	.150	.150	.150		
AI	0.140	0.160		.147	.147	.150	.150		
Accept/Reject									

Measured by:	SP
Date:	08/03/24

Audited by:	SA
Date:	08/03/24

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

